

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019974**Date Inspected:** 06-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Mr. Huang Min. .**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG BAY 5 to 8**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

BAY 6

Flux Cored Arc (FCAW) welding of welds joint CB3003D-019-001, And Welder is identified as 048625, ZPMC Quality Control (QC) is identified as Mr. Zhang Zhi Wei. The welding variables appeared to comply with the Applicable WPS-B-T-2231-B-U2-F.

Submerged Arc Welding (SAW) welding of welds joint CB3002B-018-002(CB18, BAY 6), and Welder is identified as 215960. ZPMC Quality Control (QC) is identified as Mr. Zhong Zhi Wei. The welding variables appeared to comply with the Applicable WPS-B-T-2221-B-L2C-S-2

BAY 7

Flux Cored Arc (FCAW) welding of welds joint AP3025-001-063,064, And Welder is identified as 066163, ZPMC Quality Control (QC) is identified as Mr. Shan Jian Guo. The welding variables appeared to comply with the Applicable WPS-B-T-2132-3.

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FCAW welding of welds joint AP3024-001-150,151, And Welder is identified as 068920, ZPMC Quality Control (QC) is identified as Mr. Shan Jian Guo. The welding variables appeared to comply with the Applicable WPS-B-T-2132-3.

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 06868

Magnetic Particle Testing (MT)

This QA Inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a MT report for this date. The member is identified as Steel Barrier weld. The weld designations reviewed are as follows.

1. W2-SB1G-014-050,055,044,058,062,131,036,038,048
2. W2-SB4-001-081,055,044,053,062,131,048,036,038,060
3. W2-SB1-024,-050,055,058,062,036,131,038,044,048
4. W2-SB1-026-050,055,058,062,036,131,038,044,048
5. W2-SB1-028-050,055,058,062,036,131,038,044,048
6. W2-SB1-029-050,055,058,062,036,131,038,044,048
7. W2-SB1-030-050,055,058,062,036,131,038,044,048
8. W2-SB1-031-050,055,058,062,036,131,038,044,048
9. W2-SB1-032-050,055,058,062,036,131,038,044,048
10. W2-SB1G-013-050,055,044,058,062,131,036,038,048
11. W2-SB1G-015-050,055,044,058,062,131,036,038,048
12. W2 W2-SB1G-016-050,055,044,058,062,131,036,038,048

NOTE:-Green Tag no.14445 has signed for the above mentioned component.

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 06868

Magnetic Particle Testing (MT)

This QA Inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a MT report for this date. The member is identified as CB19 weld. The weld designations reviewed are as follows.

1. SP3151-001-007,010,012,020,022,024
2. SP3151-001-051,052,053
3. SP3150-001-011~022,025,026,039,040

NOTE:-Green Tag no.14739(SP3150),14740(SP3151) has signed for the above mentioned component.

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Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Michael Ng (15921845703), who represents the Office of Structural Materials for your project.

Inspected By:	Tharikoppada,Reddy	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
